

Date: Wednesday, 3/7/2007 4:11:21 PM  
User: Kim Johnston

# **Process Sheet**

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HOOK
Job Number : 31095	
Estimate Number : 12597	
P.O. Number : <u>N/A</u>	Part Number : D30465
This Issue : 3/7/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3046 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 29793	Material : <u>N/A</u>
Written By : _____	Due Date : 3/12/2007 Qty: 50 Um: Each
Checked & Approved By : <u>[Signature] 07.03.01</u>	
Comment : Est A 06.12.01 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B0375X1000	17-4 SS Bar 3/8 x 1"
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Comment: Qty.: 0.1397 f(s)/Unit Total : 6.9825 f(s)  
17-4PH Stainless Steel Bar 3/8" x1.00"  
Batch: M102942

ml 07/03/08 51

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW  
Cut blank 1.600" long

ml 07/03/08 51

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA659 Rev: AA & Dwg D3046 Rev: B

2-Deburr per dwg D3046

ml 07/03/08 51

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07/03/08 51

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

SA 07.03.12 51

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/03/13

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 4:11:21 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HOOK

Job Number: 31095

Part Number: D30465

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WS

FC 07/02/12 (SI)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(SV)

Comment: FINAL INSPECTION/W/O RELEASE

12/07/13

Job Completion



U 07-03-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

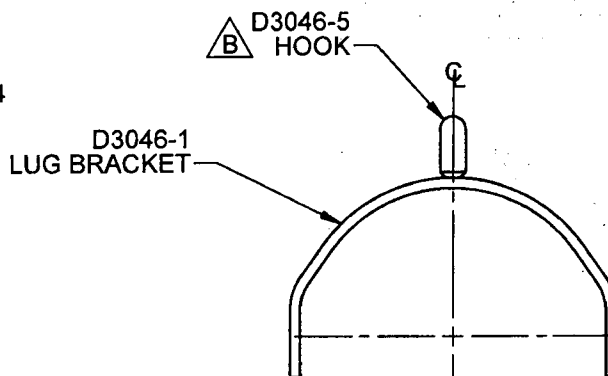
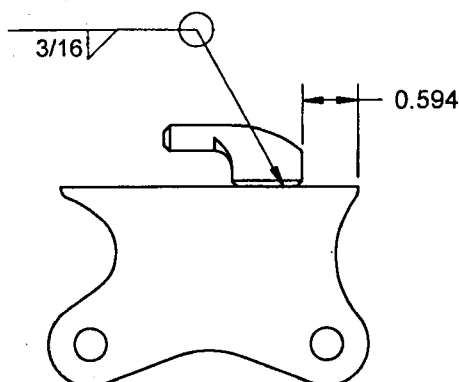
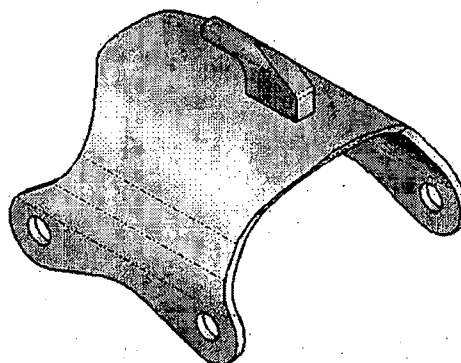
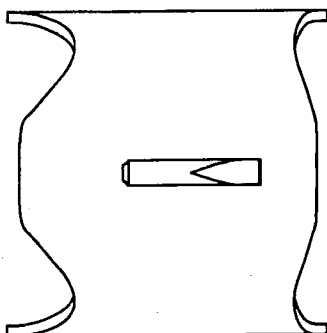
NOTE: Date & initial all entries



DESIGN #	DRAWN BY C.B.	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3046</b>	REV. B SHEET 1 OF 3
DATE <b>06.10.26</b>		TITLE <b>LUG BRACKET ASSEMBLY</b> SCALE 1:2	
REV	DATE	DESCRIPTION	
A	01.08.23	NEW ISSUE	
B	06.10.26	ADD D3046-5 REMOVE D3046-3; INCREASE HOLE DIAMETER OF D3046-1; CHANGE MATERIAL TO 17-4PH FROM 1010 STEEL	

RELEASED

06.11.13



### D3046-041 LUG BRACKET ASSEMBLY

QTY	P/N	DESCRIPTION
X	D3046-041	GROUND HANDLING LUG ASSEMBLY
1	D3046-1	LUG BRACKET
1	D3046-5	HOOK



#### NOTES:

- 1) FINISH: HEAT TREAT ASSEMBLY TO H900 HARDENED CONDITION (MIN 190 KSI) POWDER COAT ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005.4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) WELD PER DART QSI 004
- 5) PART IS SYMMETRICAL ABOUT C
- 6) IDENTIFY WITH P/N D3046-041 USING FINE POINT PERMANENT INK MARKER

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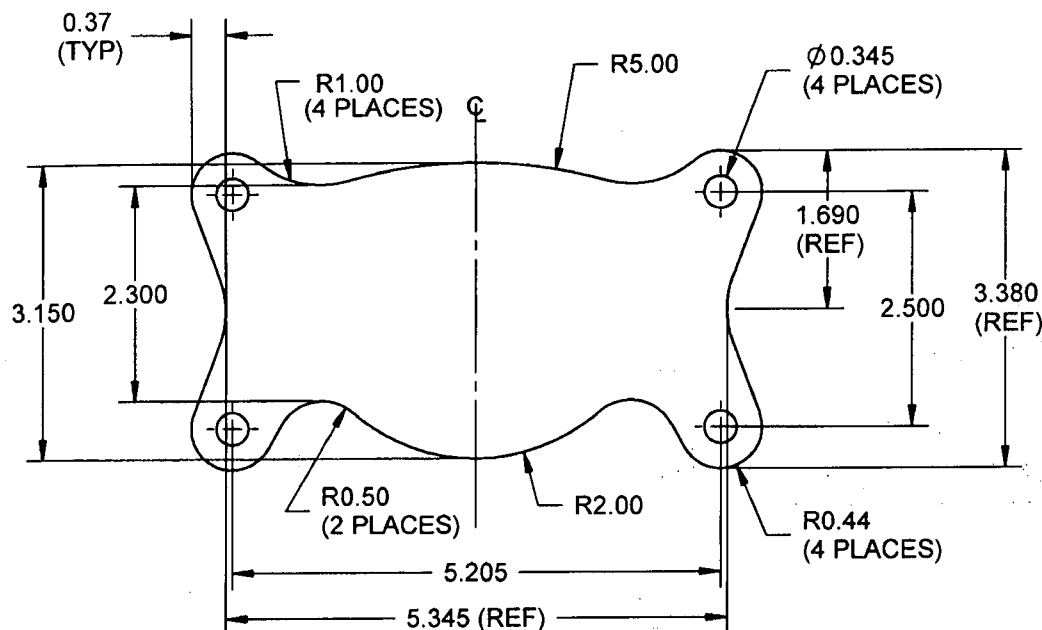
NO. **31095**

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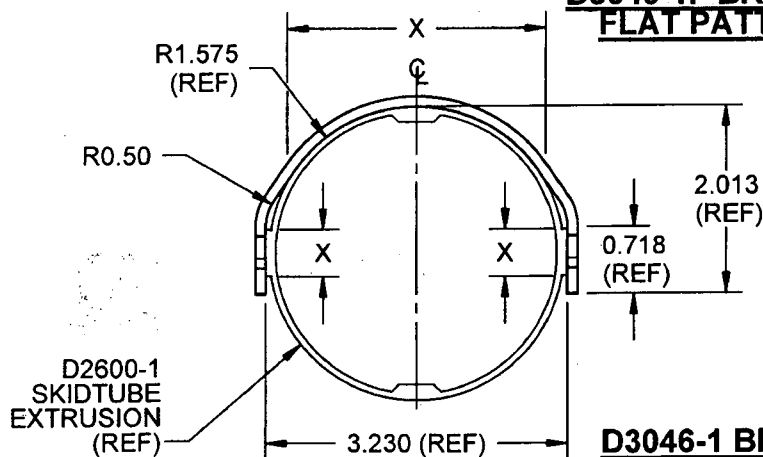
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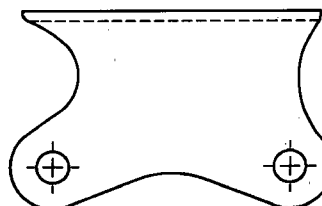
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DATE 06.10.26		TITLE LUG BRACKET ASSEMBLY	SCALE 1:2



**D3046-1F BRACKET  
FLAT PATTERN**



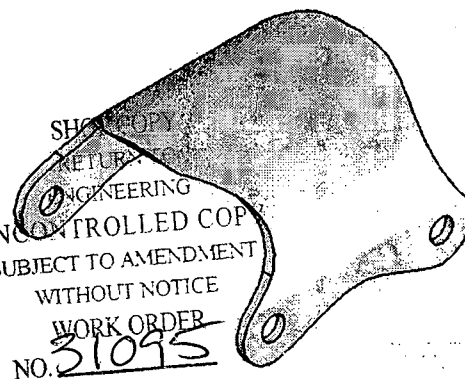
**D3046-1 BRACKET  
BEND DETAIL**

**RELEASED**

06/11/13

**NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL SHEET, 0.109" THICK (12 GAUGE) PER AMS 5604 (REF DART SPEC M17-4-S12GA)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) D3046-1 SHOULD BE BENT USING DT8351 TOOL SO THAT IT IS WITHIN 0.010" OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X'.



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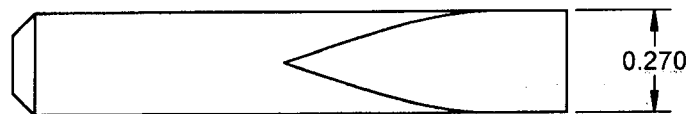
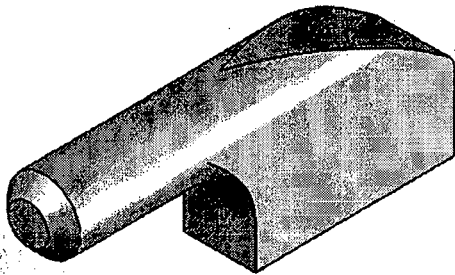
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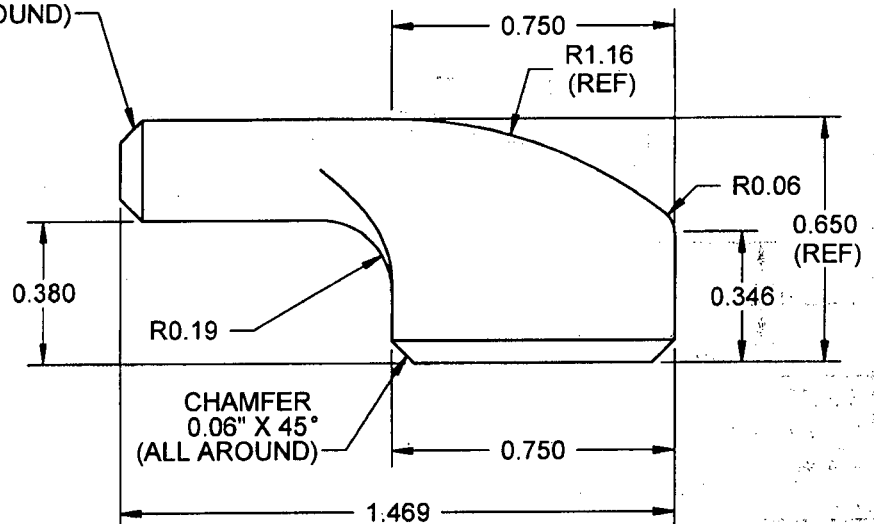
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3046	REV. B SHEET 3 OF 3
DATE 06.10.26		TITLE LUG BRACKET ASSEMBLY	SCALE 2:1

**RELEASED**

06.11.13

CHAMFER 0.06" X 45°  
(ALL AROUND)

Ø 0.270

**D3046-5 HOOK** **NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL BAR PER AMS 5604 OR AMS 5643 (REF DART SPEC. M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

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